



Dart Aerospace Ltd.
1270 Aberdeen St
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Tel (613) 632-5200

D3531-3
Job Sheet 178571



Part No: D3531-3

Job Qty: 5 ea

Part Name: Bracket Front Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/1/18

Job Tracking No:

Due Date: 6/22/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B SHEETS 4,5 IPP Rev:A New Issue 07-09-24 EC verified by DD IPP REV:B 12.10.24 PER DWG REV:B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	6/22/18	6/22/18	0.00	0.00	Start Up Waterjet		SC 18/06/09
100	Waterjet	5 pcs	6/22/18	6/22/18	0.00	0.32	Waterjet1		SC 18/06/09
120	QC	5 pcs	6/22/18	6/22/18	0.00	0.00	QC8		38
140	Brake NC	5 pcs	6/22/18	6/22/18	0.03	0.47	Brake NC 2		DAS 18/06/09
150	QC	5 pcs	6/22/18	6/22/18	0.00	0.00	QC5		38
160	HandFinish	5 pcs	6/22/18	6/22/18	0.00	0.26	HandFinish1		18-06-28
170	QC	5 pcs	6/22/18	6/22/18	0.00	0.00	QC7-2		38
180	Packaging	5 pcs	6/22/18	6/22/18	0.00	0.00	Packaging3-1		GA129 DAS 18/06/09
190	QC21-SA	5 Ea	6/22/18	6/22/18	0.00	0.00	QC21		DAS 18/06/09

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	.6565 sf (.1313 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.040	1	236	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket Front Plate	0.129Inches + 0.005 - 0.001	0.134 0.128	0.129 Diameter	
2	Bracket Front Plate	3.720Inches ± 0.030	3.750 3.690	3.718	
3	Bracket Front Plate	0.370Inches ± 0.030	0.400 0.340	0.370	
4	Bracket Front Plate	2.840Inches ± 0.010	2.850 2.830	2.837	
5	Bracket Front Plate	0.880Inches ± 0.030	0.910 0.850	0.878	
6	Bracket Front Plate	3.500Inches ± 0.030	3.530 3.470	3.498	



DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. _____		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. _____		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐	
Date: _____		Step #: _____		MRB (QS1042) Approval			
Description Work Order Deviation							
Container No: S079490 Part: D3531 - 3 Job No: 178571 Serial No/Batch: S079490 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____							
Supervisor ification ed By DART AEROSPACE Coordinator Approval Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632 - 5200 Email: sales@dartaero.com www.dartaerospace.com Date: 06/10/18							
Root Cause Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due Pressure/Force Bending Centre Not Col Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence							
OTHER : _____							

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Bracket Front Plate

4.670Inches $\pm$ 0.030

4.700

4.640

4,669

Plex 6/1/18 2:58 PM Dart.lajeunesse.marie